

Date: Wednesday, 16/07/2008 3:59:26 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT FACING SEAT KIT
Job Number	: 40573		
Estimate Number	: 13464		
P.O. Number	:	Part Number	: D412769011
This Issue	: 16/07/2008 S.O. No. :	Drawing Number	: IIN412-769 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	:	Material	:
Written By	:	Due Date	: 10/08/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JUD 08.7.16</u>		
Comment	: Est rev A 08-07-17 new issue DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JUD 08.8.13

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-769-011 CHG 001

2.0	D412769041	Aft Facing Seat, LH
-----	------------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Facing Seat, LH

batch: 40574

SC

3.0	D412769042	Aft Facing Seat, RH
-----	------------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Facing Seat, RH

batch: B40575

8/8/15 SC

4.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

8/8/15 (1)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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(1)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-769-011

Location:

PPP Rev:

A

8/8/15

SC

Jason,
 Please Cosign for
 QC 21 with
 FRIDAYS DATE
 Please
 Jmr

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 16/07/2008 3:59:26 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT KIT

Job Number: 40573

Part Number: D412769011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08-08-15

08/08/19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08-08-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011	60.0 lb	0.0 in	0.00 in-lb	87.0 in	5220 in-lb
Aft Facing Seat kit	27.2 kg	0.0 m	0.00 m-kg	2.21 m	60.11 m-kg
D412-769-041	30.0 lb	-16.1 in	-483.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (normal position)	13.6 kg	-0.41 m	-5.58 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	+16.1 in	+483.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (normal position)	13.6 kg	+0.41 m	+5.58 m-kg	2.21 m	30.06 m-kg
D412-769-041	30.0 lb	-1.1 in	-33.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (center position)	13.6 kg	-0.03 m	-0.41 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	+1.1 in	+33.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (center position)	13.6 kg	+0.03 m	+0.41 m-kg	2.21 m	30.06 m-kg
D412-769-041	30.0 lb	+13.9 in	+417.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (right Position)	13.6 kg	+0.35 m	+4.76 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	-13.9 in	-417.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (left Position)	13.6 kg	-0.35 m	-4.76 m-kg	2.21 m	30.06 m-kg

5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
	1		D412-769-043	AFT FACING SEAT ASSEMBLY, LH
		1	D412-769-044	AFT FACING SEAT ASSEMBLY, RH
	1	1	D412-724-041	HEAD REST ASSEMBLY, CENTER
	1		D412-724-043	HEAD REST ASSEMBLY, LH
		1	D412-724-044	HEAD REST ASSEMBLY, RH

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 40575 NO

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Revision: **B**

Date: 08.06.24

Date: Wednesday, 16/07/2008 3:59:30 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT FACING SEAT, LH
Job Number	: 40574		
Estimate Number	: 13462		
P.O. Number	:	Part Number	: D412769041
This Issue	: 16/07/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: IIN412-769 REV B
First Issue	: / /	Project Number	: N/A
Previous Run	:	Drawing Revision	: B
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 10/08/2008
Checked & Approved By	: <u>20 08.7.16</u>	Qty:	1 Um: Each
Comment	: Est rev A 08-07-17 new issue DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-769-041 CHG 001

N/A

2.0	D412769043	Aft Facing Seat Assembly, LH
-----	------------	------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Aft Facing Seat Assembly, LH

batch: 40000

SS 08/08/15

3.0	D412724041	Head Rest Assembly, Center
-----	------------	----------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Head Rest Assembly, Center

batch: 40168

SO

4.0	D412724043	Head Rest Assembly, LH
-----	------------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Head Rest Assembly, LH

batch: 40498

SO

8/8/15

(12)

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

16/08/15

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 16/07/2008 3:59:30 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT, LH

Job Number: 40574

Part Number: D412769041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



(13)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-769-041

Location:

PPP Rev:

Draft

8/8/15

50

7.0

QC21

FINAL INSPECTION/W/O RELEASE



2080815
08/08/19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



12 08 08 15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011	60.0 lb	0.0 in	0.00 in-lb	87.0 in	5220 in-lb
Aft Facing Seat kit	27.2 kg	0.0 m	0.00 m-kg	2.21 m	60.11 m-kg
D412-769-041	30.0 lb	-16.1 in	-483.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (normal position)	13.6 kg	-0.41 m	-5.58 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	+16.1 in	+483.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (normal position)	13.6 kg	+0.41 m	+5.58 m-kg	2.21 m	30.06 m-kg
D412-769-041	30.0 lb	-1.1 in	-33.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (center position)	13.6 kg	-0.03 m	-0.41 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	+1.1 in	+33.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (center position)	13.6 kg	+0.03 m	+0.41 m-kg	2.21 m	30.06 m-kg
D412-769-041	30.0 lb	+13.9 in	+417.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (right Position)	13.6 kg	+0.35 m	+4.76 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	-13.9 in	-417.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (left Position)	13.6 kg	-0.35 m	-4.76 m-kg	2.21 m	30.06 m-kg

5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
	1		D412-769-043	AFT FACING SEAT ASSEMBLY, LH
		1	D412-769-044	AFT FACING SEAT ASSEMBLY, RH
	1	1	D412-724-041	HEAD REST ASSEMBLY, CENTER
	1		D412-724-043	HEAD REST ASSEMBLY, LH
		1	D412-724-044	HEAD REST ASSEMBLY, RH

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 WORK ORDER
 NO. 40574

Date: Wednesday, 16/07/2008 3:59:34 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT FACING SEAT, RH
Job Number	: 40575		
Estimate Number	: 13463		
P.O. Number	:	Part Number	: D412769042
This Issue	: 16/07/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: IIN412-769 REV B
First Issue	: //	Project Number	: N/A
Previous Run	:	Drawing Revision	: B
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 10/08/2008
Checked & Approved By	: <u>JUL 08.7.16</u>	Qty:	1 Um: Each
Comment	: Est rev A 08-07-17 new issue DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-769-042 CHG 001 N/A

2.0	D412769044	Aft Facing Seat Assembly, RH
-----	------------	------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Facing Seat Assembly, RH

batch: 40001

3.0	D412724041	Head Rest Assembly, Center
-----	------------	----------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Head Rest Assembly, Center

batch: 40168

4.0	D412724044	Head Rest Assembly, RH
-----	------------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Head Rest Assembly, RH

batch: 40169

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 16/07/2008 3:59:34 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT, RH

Job Number: 40575

Part Number: D412769042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-769-042

Location:

PPP Rev:

Draft

8/8/15

7.0

QC21

FINAL INSPECTION/W/O RELEASE



8-08-15
08/08/19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08-08-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011 Aft Facing Seat kit	60.0 lb 27.2 kg	0.0 in 0.0 m	0.00 in-lb 0.00 m-kg	87.0 in 2.21 m	5220 in-lb 60.11 m-kg
D412-769-041 Aft Facing Seat, LH (normal position)	30.0 lb 13.6 kg	-16.1 in -0.41 m	-483.0 in-lb -5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (normal position)	30.0 lb 13.6 kg	+16.1 in +0.41 m	+483.0 in-lb +5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (center position)	30.0 lb 13.6 kg	-1.1 in -0.03 m	-33.0 in-lb -0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (center position)	30.0 lb 13.6 kg	+1.1 in +0.03 m	+33.0 in-lb +0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (right Position)	30.0 lb 13.6 kg	+13.9 in +0.35 m	+417.0 in-lb +4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (left Position)	30.0 lb 13.6 kg	-13.9 in -0.35 m	-417.0 in-lb -4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg

5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
	1		D412-769-043	AFT FACING SEAT ASSEMBLY, LH
		1	D412-769-044	AFT FACING SEAT ASSEMBLY, RH
	1	1	D412-724-041	HEAD REST ASSEMBLY, CENTER
	1		D412-724-043	HEAD REST ASSEMBLY, LH
		1	D412-724-044	HEAD REST ASSEMBLY, RH

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Revision: B
Date: 08.06.24

Date: Friday, 15/08/2008 2:30:26 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : REPLACEMENT WINDOW KIT
Job Number : 41259	
Estimate Number : 12349	
P.O. Number :	Part Number : D350567113
This Issue : 15/08/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : N/A
Previous Run : 41099A	Material :
Written By :	Due Date : 22/08/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 04-08-24 New Issue JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD350-567-113 CHG002



2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

ENSURE DT 8439 TEMPLATE IS INCLUDED

3.0	D2463	Seal
-----	-------	------



Comment: Qty.: 7.5243 f(s)/Unit Total : 7.5243 f(s)
1/2" Seal 86.6" Long
Batch: 38677

4.0	D3290041	Replacement Window Assembly
-----	----------	-----------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Replacement Window Assy
Batch: 39870

5.0	21212	Receptacles
-----	-------	-------------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Receptacles
Batch: 107203

-Date: Friday, 15/08/2008 2:30:26 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW KIT

Job Number: 41259

Part Number: D350567113

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

26006

Camlock Stud



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Camlock Stud

Batch: 108606

AS 08/08/15 (X)

7.0

2600LW

Camloc Retaining Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Camloc Retaining Washer

Batch: M107600 x 4 M108607 x 8

AS 08/08/15 (X)

8.0

AN526C832R9

Screw



Comment: Qty.: 21.0000 Each(s)/Unit Total: 21.0000 Each(s)

Screw

Batch: M108377

AS 08/08/15 (X)

9.0

AN960JD8

Washer



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

Washer

Batch: M107650

AS 08/08/15 (X)

10.0

MS20426AD34

RIVET



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

RIVET

Batch: M105978

AS 08/08/15 (X)

11.0

MS21042L08

Nut



Comment: Qty.: 21.0000 Each(s)/Unit Total: 21.0000 Each(s)

Nut

Batch: M07990

AS 08/08/15 (X)

12.0

FG778150550ROL

7781 9oz Glass 50"x125yd



Comment: Qty.: 18.0000 sf(s)/Unit Total: 18.0000 sf(s)

2sq yd of 7781 9oz Glass 50"x125yd

Batch: 104845

AS 08/08/15 (X)

Date: Friday, 15/08/2008 2:30:26 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW KIT

Job Number: 41259

Part Number: D350567113

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

106-06-15

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-567-113

Location: _____

PPP Rev: _____

Rev C

AS 08/08/15
106-06-15
08/08/19

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08-08-15